

Work Order ID 150816

Thursday, September 08, 2016 8:01:48 AM

150816

Page 1

AMOD
Drab Green

Item ID: D412-630-032DG Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear, Drab Green
 Start Date: 9/8/2016 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 9/30/2016 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: W Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN D412-630	O						DAS 21 9-89	16-09-08	40
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy D412-630 bluefile & type labels per PPP412-630-032 CHG004								
110		0.00							
110	Small Fab								
Small Fab	Memo	0.16							
Small Fab	Assemble as per IIN D412-630								
****ensure tension to retract step is 11 to 18 lbs before installing lockwire.****									
A/R MS20995C41 batch: 131371									

4x smfs
10/9/23

4x 16/09/22 DAS 36 9-89

DAS

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N900040100

Setup Start *NS1*

Stop ***NS2***

Stop ***NS2***

Start Date: 9/8/2016 **Start Qty:** 4.00 ***4***

Cust Item ID:

Required Date: 9/30/2016 **Req'd Qty:** 4.00 ***4***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

[illegible]

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Item ID: D412-630-032DG **Accept** ***N900040100*** **Setup Start *NS1***
Revision ID: **Stop *NS2***
Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear, Drab Green
Start Date: 9/8/2016 **Start Qty:** 4.00 ***4*** **Cust Item ID:**
Required Date: 9/30/2016 **Req'd Qty:** 4.00 ***4*** **Customer:**
Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Run Start *NR1***
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150		0.00							
150	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-630-032 ENSURE STEP IS A RH: _____ Location;FG034 Sold								
160		0.00							
160	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.07							
Quality Control									

4X **SMB**
10/9/23

DAS
21
9-89

SEP 23 2016

dm 10/09/23

Picklist Print

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Work Order ID: 150816

150816

Parent Item: D412-630-032DG

D412-630-032DG

Parent Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear, Drab Green

Start Date: 9/8/2016

Required Date: 9/30/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV. A 05.11.21 NEW ISSUE EC
 IPP REV. B 05.12.19 updated pick list EC
 IPP REV. C 07.11.12 ecn 1019, nochg EC verified by: DD IPP Rev: D
 10.05.28 added route seq DD verf: EC IPP Rev: E 11.06.01
 removed qty1 an310-4 EC verified by: DD IPP REV: F 16.06.23 AS PER
 IIN REV. O DD VERF: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN310-4

Purchased

No

110

Each

169.0000

1

4

AN310-4

Nut

**

Location

Loc Qty

Loc Code

GA

25

M127815

25

OVER007

100

M135442

100

ST331

44

M134955

44

AN310-7

Purchased

No

110

Each

65.0000

1

4

AN310-7

Nut

**

Location

Loc Qty

Loc Code

ST331

65

124198

25

m120124

40

AN4C14

Purchased

No

110

Each

32.0000

1

4

AN4C14

Bolt

**

Location

Loc Qty

Loc Code

ST344

32

m131264

2

m135084

30

SEP 19 2016

DAS
6
9-8g

DAS
6
9-8g

DAS
6
9-8g

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Parent Item: D412-630-032DG

D412-630-032DG

Parent Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear, Drab Green

Start Date: 9/8/2016

Required Date: 9/30/2016

Start Qty: 4.00

Required Qty: 4.00

AN4CH3

Purchased

No

110

Each

83.0000

2

8

AN4CH3

Bolt

DAS
6
8-89

Location

Loc Qty

Loc Code

ST346

83

M132124

8

M135482

75

110

Each

1.0000

1

4

D3443-041

Manufactured

No

D3443-041

Strut Weldment Assembly

Location

Loc Qty

Loc Code

ST525

1

144279

1

110

Each

1.0000

1

4

D3443-043

Manufactured

No

D3443-043

Strut Weldment Assembly

Location

Loc Qty

Loc Code

ST525

1

145453

1

110

Each

115.0000

2

8

D3443-9

Manufactured

No

D3443-9

Pin

Location

Loc Qty

Loc Code

ST037

115

145541

14

149322

101

DAS
6
8-89

SEP 19 2016

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Parent Item: D412-630-032DG

D412-630-032DG

Parent Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear, Drab Green

Start Date: 9/8/2016

Required Date: 9/30/2016

Start Qty: 4.00

Required Qty: 4.00

D3454-7

Manufactured No

110

Each

124.0000

2

8

D3454-7

Bushing

★★

DAS
6
9-89

Location

Loc Qty

Loc Code

ST037

22

144631

22

ST038A

102

149466

102

D3455-1

Manufactured No

110

Each

373.0000

2

8

D3455-1

Spacer

★★

DAS
6
9-89

Location

Loc Qty

Loc Code

ST037

66

147371

66

ST038A

307

149364

307

D3463-042

Manufactured No

110

Each

2.0000

1

4

D3463-042

Step Weldment Assembly

★★

SEP 19 2016

DAS
36
9-89

Location

Loc Qty

Loc Code

ST386

2

144282

2

D3465-1

Manufactured No

110

Each

96.0000

1

4

D3465-1

Washer

★★

DAS
6
9-89

Location

Loc Qty

Loc Code

ST038

96

148257

44

149356

52

SEP 19 2016

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Work Order ID: 150816

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Parent Item: D412-630-032DG

D412-630-032DG

Parent Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear, Drab Green

Start Date: 9/8/2016

Required Date: 9/30/2016

Start Qty: 4.00

Required Qty: 4.00

MS24665-227

Purchased

No

110

Each

105.0000

1

4

MS24665-227

Cotter Pin

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

16

111041

16

ST289

89

m127831

89

MS24665-302

Purchased

No

110

Each

29.0000

1

4

MS24665-302

Cotter Pin

135672

DAS
6
9-89

Location

Loc Qty

Loc Code

GA

15

120521

15

ST288

14

m134738

14

AN310-4

Purchased

No

130

Each

169.0000

1

4

AN310-4

Nut

DAS28
6-9-89
9-89

Location

Loc Qty

Loc Code

GA

25

M127815

25

OVER007

100

M135442

100

ST331

44

M134955

44

DAS
27
9-89

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Work Order ID: 150816

150816

Parent Item: D412-630-032DG

D412-630-032DG

Parent Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear, Drab Green

Start Date: 9/8/2016

Required Date: 9/30/2016

Start Qty: 4.00

Required Qty: 4.00

AN310-5

Purchased

No

130

Each

25.0000

2

8

AN310-5

Nut

**

DAS
6 28
9-89 9-89

Location

Loc Qty

Loc Code

ST331

25

m129706

9

m131320

16

AN3C5A

Purchased

No

130

Each

1,277.000

3

12

AN3C5A

Bolt

**

DAS
6 28
9-89 9-89

Location

Loc Qty

Loc Code

FG

5

122800

5

FP001

199

M134955

174

M135470

25

OVER002

800

M135297

600

M135442

200

ST350

273

M133234

1

M134676

272

AN44-C12

Purchased

No

130

Each

12.0000

1

4

AN44-C12

Eye Bolt

**

DAS
6 28
9-89 9-89

Location

Loc Qty

Loc Code

FG

3

124829

3

ST339

9

M132879

4

M135297

5

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Work Order ID: 150816

150816

Parent Item: D412-630-032DG

D412-630-032DG

Parent Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear, Drab Green

Start Date: 9/8/2016

Required Date: 9/30/2016

Start Qty: 4.00

Required Qty: 4.00

AN4C15

Purchased

No

130

Each

29.0000

1

4

AN4C15

Bolt

**

28
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

OVER002

15

M135046

15

ST343

14

M1134567

14

AN5C11

Purchased

No

130

Each

11.0000

1

4

AN5C11

BOLT

**

DAS 28
6 9-89

Location

Loc Qty

Loc Code

ST338

11

M134887

11

AN5C15

Purchased

No

130

Each

14.0000

1

4

AN5C15

BOLT

**

DAS 28
6 9-89

Location

Loc Qty

Loc Code

ST337

14

M132317

4

M135297

10

D3454-1

Manufactured

No

130

Each

58.0000

1

4

D3454-1

Bushing

**

DAS 28
6 9-89

Location

Loc Qty

Loc Code

ST037

58

146027

10

149447

48

SEP 20 2016

DAS
27
9-89

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Work Order ID: 150816

150816

Parent Item: D412-630-032DG

D412-630-032DG

Parent Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear, Drab Green

Start Date: 9/8/2016

Required Date: 9/30/2016

Start Qty: 4.00

Required Qty: 4.00

D3454-3

Manufactured No

130

Each

123.0000

2

8

D3454-3

Bushing

**

1199326x2

DAS 28
6 9-89
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST037

123

121223

22

149416

101

8

D3454-5

Manufactured No

130

Each

117.0000

2

8

D3454-5

Bushing

**

2x B 1199326x2

DAS 28
6 9-89
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST037

13

148239

13

ST038A

104

145571

3

149326

101

6

D3455-1

Manufactured No

130

Each

373.0000

4

16

D3455-1

Spacer

**

DAS 28
6 9-89
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST037

66

147371

66

ST038A

307

149364

307

16

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Work Order ID: 150816

150816

Parent Item: D412-630-032DG

D412-630-032DG

Parent Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear, Drab Green

Start Date: 9/8/2016

Required Date: 9/30/2016

Start Qty: 4.00

Required Qty: 4.00

D3455-3

Manufactured No

130 Each

117.0000

2 8

D3455-3

Spacer

**

DAS
6 28
9-89 9-89

Location

Loc Qty

Loc Code

ST037

95

146067

11

149459

84

ST038A

22

149312

22

D3462-042

Manufactured No

130 Each

2.0000

1 4

D3462-042

Bracket Assembly

**

149441

DAS
6 28
9-89 9-89

Location

Loc Qty

Loc Code

ST038

2

146512

2

D3672-5

Manufactured No

130 Each

622.0000

1 4

D3672-5

Washer, Phenolic

**

28
9-89

Location

Loc Qty

Loc Code

FG

8

44679

8

ST049

234

35521

234

ST051A

380

50354

380

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Work Order ID: 150816

150816

Parent Item: D412-630-032DG

D412-630-032DG

Parent Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear, Drab Green

Start Date: 9/8/2016

Required Date: 9/30/2016

Start Qty: 4.00

Required Qty: 4.00

MS21043-3

Purchased

No

130

Each

1,202.000

3

12

MS21043-3

Nut

**

DAS 28
6 9-89
9-89

DAS 27
9-89

Location

Loc Qty

Loc Code

FG	80	
103691	80	
FP001	11	
m130673	11	
GA	235	
m133990	235	
ST302	807	
m135058	7	
m135442	400	12
m135544	400	
ST304	69	
m131340	69	

MS24665-227

Purchased

No

130

Each

105.0000

1

4

MS24665-227

Cotter Pin

**

DAS 28
6 9-89
9-89

DAS 27
9-89

Location

Loc Qty

Loc Code

GA	16	
111041	16	
ST289	89	
m127831	89	4

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Work Order ID: 150816

150816

Parent Item: D412-630-032DG

D412-630-032DG

Parent Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear, Drab Green

Start Date: 9/8/2016

Required Date: 9/30/2016

Start Qty: 4.00

Required Qty: 4.00

MS24665-229

Purchased

No

130

Each

71.0000

2

8

MS24665-229

Cotter Pin

**

DAS 28
6 9-89
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

GA

5

118234

5

ST289

66

m132123

66

NAS1149C0363R

Purchased

No

130

Each

478.0000

7

28

NAS1149C0363R

Washer

**

134462 135672 28
DAS 9-89
6 9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

FP001

265

114742

6

m133077

259

GA

213

m133077

213

NAS1149C0563R

Purchased

No

130

Each

422.0000

1

4

NAS1149C0563R

Washer

**

DAS 28
6 9-89
9-89

DAS
27
9-89

Location

Loc Qty

Loc Code

ST265

422

m131697

422

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Work Order ID 150816

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150816AMOD
Drab Green

Page 1

Item ID: D412-630-032DG

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Pilot/Co-Pilot Folding Step RH - Low, High & Float Gear, Drab Green

Stop

NS2

Start Date: 9/8/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 9/30/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN D412-630

O

54

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy D412-630 bluefile & type labels per PPP412-630-032 CHG004

DAS
21
9-89

SEP 08 2016

4

110

Small Fab

0.00

110

Small Fab

Memo

0.16

Small Fab

Assemble as per IIN D412-630

****ensure tension to retract step is 11 to 18 lbs before installing lockwire.****

A/R MS20995C41 batch:_____

Qty -031	Qty -032	Part Number	Description
X		D412-630-031	PILOT/CO-PILOT STEP, LH (FOLDING)
	X	D412-630-032	PILOT/CO-PILOT STEP, RH (FOLDING)
1	1	D3443-041	STRUT ASSEMBLY
1	1	D3443-043	STRUT ASSEMBLY
2	2	D3443-9	PIN
1	1	D3454-1	BUSHING
2	2	D3454-3	BUSHING
2	2	D3454-5	BUSHING
2	2	D3454-7	BUSHING
6	6	D3455-1	SPACER
2	2	D3455-3	SPACER
1		D3462-041	BRACKET ASSEMBLY
	1	D3462-042	BRACKET ASSEMBLY
1		D3463-041	STEP ASSEMBLY
	1	D3463-042	STEP ASSEMBLY
1	1	D3465-1	WASHER
1	1	D3672-5	WASHER (OR NAS1515H5)
2	2	AN310-4	NUT
2	2	AN310-5	NUT
1	1	AN310-7	NUT
2	2	AN3C5A	BOLT
1	1	AN3C6A	BOLT
1	1	AN44-C12	* EYEBOLT
1	1	AN4C14	BOLT
1	1	AN4C15	BOLT
2	2	AN4CH3	BOLT
1	1	AN5C11	BOLT
1	1	AN5C15	BOLT
7	7	NAS1149C0363R	WASHER (OR AN960C10)
1	1	NAS1149C0563R	WASHER (OR AN960C516)
3	3	MS21043-3	NUT
2	2	MS24665-227	COTTER PIN
2	2	MS24665-229	COTTER PIN
1	1	MS24665-302	COTTER PIN

* USE AN44-C12 EYEBOLT WHEN D412-630-031/-032 IS INSTALLED IN CONJUNCTION WITH D412-630-023/-024/-033/-034™ HELI-ACCESS-STEP.
SEE FIGURE 13B (D412-630-023/-024 KITS) OR FIGURE 16B (D412-630-033/-034 KITS).